

Date: Friday, 12/21/2007 7:27:41 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 STEP END PLATE
Job Number	: 36520		
Estimate Number	: 11021		
P.O. Number	: <u>N/A</u>	Part Number	: D2734
This Issue	: 12/21/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2734 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 34485	Material	: <u>N/A</u>
Written By	: <u>12.21.07</u>	Due Date	: 1/20/2008 Qty: 200 Um: Each
Checked & Approved By	: <u>12.21.07</u>		
Comment	: Est:D 01.06.08 Removed Deburr EC Est Rev:E 07-12-18 RevC as per dwg ECN1048 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S063	5052-H32 .063 Sheet
-----	--------------	---------------------



14,000



Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: 103755

IB 8-1-4

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D 2734

Dwg Rev: CProg Rev: C

IB 8-1-4

2-Deburr if necessary

08/01/08

Jm

210

210

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-1-4



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



QSP019



Comment: SECOND CHECK

08/01/09 210

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per drawing D2734

SR 08/01/09 210

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 08/01/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 STEP END PLATE

Job Number: 36520

Part Number: D2734

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



QSP019



counters

Comment: INSPECT WORK TO CURRENT STEP

208/01/16 (210)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 3

208.01.16 (210)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/16

Job Completion



2008/1/16

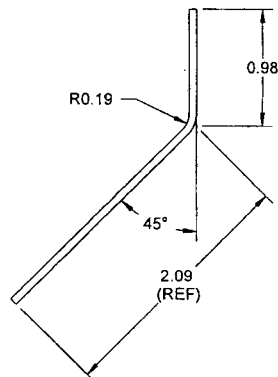
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

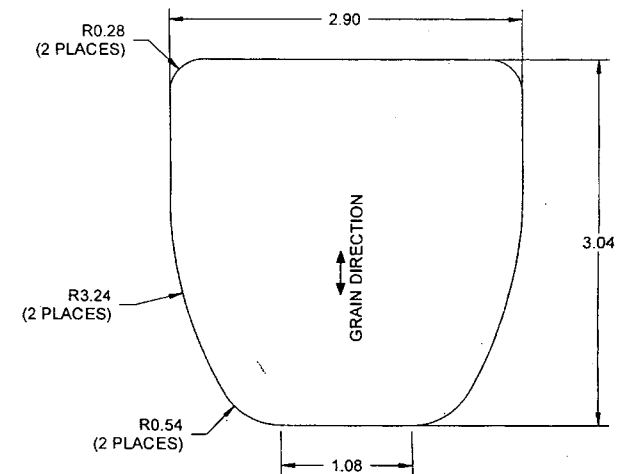
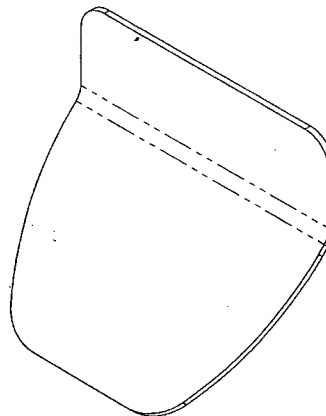
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2734 END PLATE



D2734 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 36520

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T6) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

RELEASED
07.12.12

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2734 TITLE END PLATE SCALE 1:1 <small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	DC		
CHECKED	h		
MFG. APPR.	RP		
APPROVED	MP		
DE APPR.	MP	REV. C SHEET 1 OF 1	
DATE	07.11.20		